

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024594**Date Inspected:** 08-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

**WELDING**

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

**Flux Cored Arc Welding (FCAW)**

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020M-144 located on Floor Beam to Bottom Plate of the OBG Segment 14W. The welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020R-032 located on Floor Beam of the OBG Segment 14W. The welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020L-085 located on Floor Beam to Bottom plate of the OBG Segment 14W. The welder is identified as 045276. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3019AG-011 located on Edge Plate to Side Plate of the OBG Segment 14W. The welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020BB-037 located on Side Plate of the OBG Segment 14W. The welder is identified as 068445. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

### Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020M-015 located on Bottom Plate of the OBG Segment 14W. The welder is identified as 037780. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM Repair and B-CWR19824.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020K-028 located on Floor Beam to Longitudinal Diaphragm of the OBG Segment 14W. The welder is identified as 067611. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020R-133 located on Floor Beam at PP126 of the OBG Segment 14W. The welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Liming Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020AB-103 located on Bottom Plate to Longitudinal Diaphragm of the OBG Segment 14W. The welder is identified as 067610. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020J-002 located on the OBG Segment 14W. The welder is identified as 037840. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Singh,Vikram	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

---